

**Work Order ID 157223**

Tuesday, February 21, 2017 7:57:12 AM

**\*157223\***

Item ID: D2893-1

Accept

**\*N900040100\***Setup Start **\*N**

Revision ID:

Stop **\*N**

Item Name: Support

Start Date: 2/3/2017

Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 2/17/2017

Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

DAS  
21  
9-89

Approvals:

Process Plan:

Date: FEB 21 2017

Tooling:

Date:

Run Start **\*N**

QC:

Date:

SPC (Y/N):

Date:

Stop **\*N**

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|

Draw Nbr

Revision Nbr

D2893

C

100

0.10

**\*100\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.69

HAAS CNC vertical machine #1

1-Machine as per Folio FA081  
2-Deburr

10 0 DAS 44 9-89 17-03-17 17/03/17

110

0.00

**\*110\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10 0 DAS 44 9-89 17-03-17 17/03/17

120

0.00

**\*120\***

QC8- Inspect parts - second check

QC

Memo

0.03

Quality Control

10 0 DAS 08 9-89 17-03-17

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                   | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                      | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Step #: _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | QTY Effective : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | MRB (QSI042) Approval                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Completed By                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Lead hand / Supervisor Approval Verification                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | QC / QA Coordinator Approval                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Root Cause                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | FAULT CATEGORY                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Environment <input type="checkbox"/><br>Design <input type="checkbox"/><br>Doc/Data <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Pre <input type="checkbox"/><br>Material <input type="checkbox"/><br>Internal Transport <input type="checkbox"/><br>Tribal Knowledge <input type="checkbox"/><br>LOA <input type="checkbox"/><br>Substation <input type="checkbox"/><br>Past Expiry Date <input type="checkbox"/><br>Misidentified <input type="checkbox"/> | No Re-verification <input type="checkbox"/><br>Operator <input type="checkbox"/><br>Offset/Setup <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Training <input type="checkbox"/><br>Use for Testing <input type="checkbox"/><br>Poor Information <input type="checkbox"/><br>Rushing <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Past Due <input type="checkbox"/> | Pressure/Forced <input type="checkbox"/><br>Bending <input type="checkbox"/><br>Centre Not Concentric <input type="checkbox"/><br>Cracks <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave <input type="checkbox"/><br>Cuffs <input type="checkbox"/><br>Crushing <input type="checkbox"/><br>Heat Treat <input type="checkbox"/><br>Wave/Twist in Tube <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Temperature/Cure <input type="checkbox"/><br>Set-up <input type="checkbox"/><br>BOM/Route <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/><br>Inspection Incomplete/Unqualified <input type="checkbox"/><br>Contamination <input type="checkbox"/><br>Countersink <input type="checkbox"/><br>Cut Too Short <input type="checkbox"/><br>Instructions Incomplete/Unclear <input type="checkbox"/><br>Drill Holes <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/><br>Folio/Program <input type="checkbox"/><br>Grain <input type="checkbox"/><br>Weld <input type="checkbox"/><br>Wrong Stock Pulled <input type="checkbox"/><br>Out of Sequence <input type="checkbox"/><br>Off-set <input type="checkbox"/><br>Mislabeled <input type="checkbox"/><br>Fit/Function <input type="checkbox"/><br>Misaligned/off center <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/><br>Outside Dimensions <input type="checkbox"/><br>Over/Under tolerance <input type="checkbox"/><br>Part Incorrect <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/><br>Part Moved <input type="checkbox"/><br>Drawing <input type="checkbox"/><br>Finish <input type="checkbox"/><br>Misread <input type="checkbox"/><br>Turning Sequence <input type="checkbox"/> |
| OTHER : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |

**Work Order ID 157223**

Tuesday, February 21, 2017 7:57:13 AM

**\*157223\***

Page 2

Item ID: D2893-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Support

Start Date: 2/3/2017 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 2/17/2017 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00

**\*130\***

HandFXtube

**Memo**

0.00

Hand Finishing Crosstubes

Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time.

10

DAS  
41  
9-89

MAR 17 2017

140

QC3- Inspect Part Finish

0.00

**\*140\***

QC

**Memo**

0.01

Quality Control

10

DAS  
38  
9-89

MAR 20 2017

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*170\***

Packaging

**Memo**

0.01

Packaging

LOCATION : LG050

10

MAR 20 2017

DAS  
38  
9-89

**Work Order ID 157223**

Tuesday, February 21, 2017 7:57:13 AM

**\*157223\***

Page 3

Item ID: D2893-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Support

Start Date: 2/3/2017 Start Qty: 8.00

**\*g\***

Cust Item ID:

Required Date: 2/17/2017 Req'd Qty: 8.00

**\*g\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.13

Quality Control

DAS  
21  
9-89

MAR 20 2017



# Picklist Print

Tuesday, February 21, 2017 7:57:15 AM

Page 1

Work Order ID: 157223

\*157223\*

Parent Item: D2893-1

\*D2893-1\*

Parent Item Name: Support

Start Date: 2/3/2017

Required Date: 2/17/2017

Start Qty: 8.00

Required Qty: 8.00

**Comments:**

IPP: C02.11.26Reformat; Added P/OKJ  
IPP D 06.04.19 removed alodine EC  
IPP Rev:E Added priming as per Rev B 07-04-30 JLM  
IPP F 08.03.19 Re-format EC verified by: DD  
IPP Rev:G 08-05-15 add QC14 DD verified by:EC  
11.08.04 as per dwg rev.C DD verf:EC  
IPP Rev:H

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| DSK078                          |                        | Manufactured  | No          |                     |                  | 100             | Each               | 10.0000        | 0.5         | 4            |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |             |              | DAS           |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |             |              | 44            |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |             |              | 9-89          | 17-03-11       |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |

\*DSK078\*

D2893-1 Turning Detail

Location

Loc Qty

Loc Code

MAT060

10

155454

10

5

|                                    |               |                     |         |
|------------------------------------|---------------|---------------------|---------|
| <b>DART AEROSPACE LTD</b>          |               | <b>Work Order:</b>  | 157223  |
| <b>Description: Ø2.750 Support</b> |               | <b>Part Number:</b> | D2893-1 |
| <b>Inspection Dwg: D2893</b>       | <b>Rev: C</b> | <b>Page 1 of 1</b>  |         |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

|               |       |       |                | Record Actual Dimensions |       |       |       |       |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                        | 2     | 3     | 4     | 5     |
| HAAS Section  |       |       |                |                          |       |       |       |       |
| AA            | 2.985 | 3.005 |                | 2.992                    | 2.990 | 2.990 | 2.990 | 2.994 |
| AB            | 0.440 | 0.460 |                | .450                     | .450  | .450  | .450  | .450  |
| AC            | 0.125 | 0.160 |                | .135                     | .135  | .135  | .138  | .138  |
| AD            | 0.040 | 0.060 |                | .050                     | .050  | .050  | .050  | .050  |
| AE            | 0.188 | 0.193 |                | .190                     | .190  | .190  | .190  | .190  |
| AF            | 0.125 | 0.160 |                | .138                     | .139  | .138  | .139  | .138  |
| AG            | 0.140 | 0.160 |                | .148                     | .147  | .147  | .147  | .148  |
| AH            | 1.360 | 1.400 |                | 1.379                    | 1.377 | 1.378 | 1.379 | 1.382 |
| AI            | 0.040 | 0.060 |                | .053                     | .048  | .049  | .049  | .050  |
| AJ            | 1.190 | 1.230 |                | 1.220                    | 1.220 | 1.221 | 1.222 | 1.222 |
| AK            | 0.010 | 0.020 |                | .015                     | .015  | .015  | .015  | .015  |
| AL            | 0.053 | 0.073 |                | .063                     | .063  | .063  | .063  | .063  |
| AM            | 0.240 | 0.260 |                | .250                     | .250  | .250  | .250  | .250  |
| AN            | 2.518 | 2.538 |                | 2.528                    | 2.528 | 2.528 | 2.528 | 2.528 |
| AO            | 84.39 | 90.39 |                | 87.39                    | 87.39 | 87.39 | 87.39 | 87.39 |
| AP            | 0.261 | 0.266 |                | .262                     | .262  | .262  | .262  | .262  |
| AQ            | 0.053 | 0.073 |                | .063                     | .063  | .063  | .063  | .063  |
| AR            |       |       |                |                          |       |       |       |       |
| AS            |       |       |                |                          |       |       |       |       |
| AT            |       |       |                |                          |       |       |       |       |
| Accept/Reject |       |       |                | ✓                        | ✓     | ✓     | ✓     | ✓     |

|                              |                   |              |          |
|------------------------------|-------------------|--------------|----------|
| <b>Measured by:</b>          | DAS<br>44<br>9-89 | <b>Date:</b> | 17-03-12 |
| <b>Audited by:</b>           | DAS<br>08<br>9-89 | <b>Date:</b> | 17-03-17 |
| <b>Preliminary Approval:</b> |                   | <b>Date:</b> |          |

| Rev | Date     | Change               | Revised by | Approved |
|-----|----------|----------------------|------------|----------|
| A   | 02.12.13 | New Issue            | KJ/RF      |          |
| B   | 07.05.08 | Dimension AP revised | KJ/JLM     |          |
| C   | 08.04.21 | Reformat             | KJ/JLM     |          |
| D   | 12.07.31 | Dwg Rev updated      | KJ         |          |



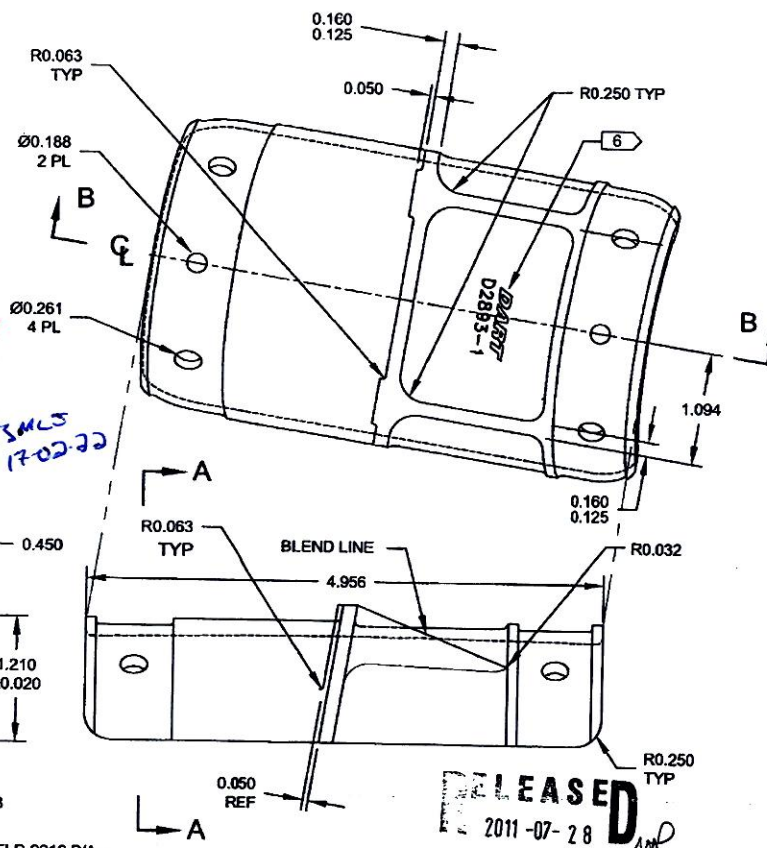
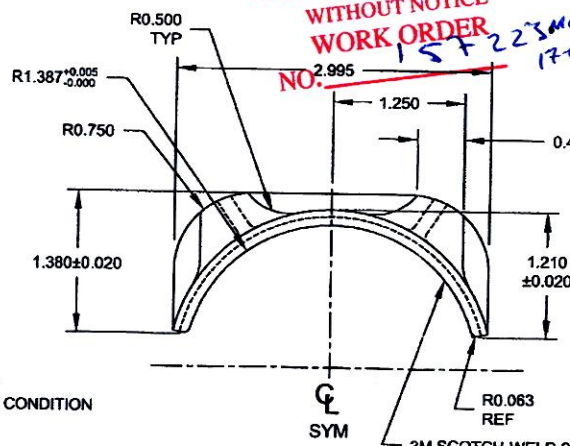
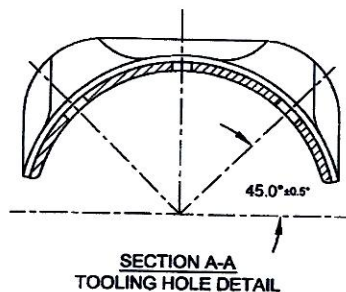
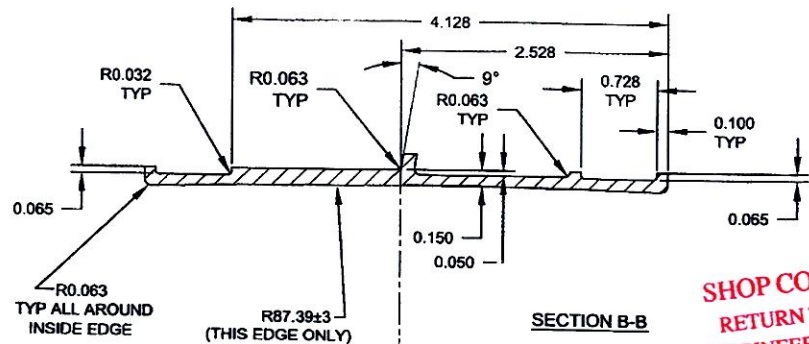
|                                    |               |                             |
|------------------------------------|---------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>          |               | <b>Work Order:</b> 157223   |
| <b>Description: Ø2.750 Support</b> |               | <b>Part Number:</b> D2893-1 |
| <b>Inspection Dwg: D2893</b>       | <b>Rev: C</b> | <b>Page 1 of 1</b>          |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

|               |       |       |                | Record Actual Dimensions |       |       |       |       |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim           | Min   | Max   | Go/No Go Gauge | 6                        | 7     | 8     | 9     | 10    |
| HAAS Section  |       |       |                |                          |       |       |       |       |
| AA            | 2.985 | 3.005 |                | 2.994                    | 2.993 | 2.993 | 2.996 | 2.998 |
| AB            | 0.440 | 0.460 |                | .450                     | .450  | .450  | .450  | .450  |
| AC            | 0.125 | 0.160 |                | .137                     | .137  | .138  | .143  | .140  |
| AD            | 0.040 | 0.060 |                | .050                     | .050  | .050  | .050  | .051  |
| AE            | 0.188 | 0.193 |                | .190                     | .190  | .190  | .190  | .190  |
| AF            | 0.125 | 0.160 |                | .138                     | .138  | .136  | .140  | .140  |
| AG            | 0.140 | 0.160 |                | .144                     | .146  | .145  | .145  | .145  |
| AH            | 1.360 | 1.400 |                | 1.379                    | 1.380 | 1.382 | 1.373 | 1.375 |
| AI            | 0.040 | 0.060 |                | .045                     | .048  | .046  | .054  | .052  |
| AJ            | 1.190 | 1.230 |                | 1.217                    | 1.220 | 1.222 | 1.217 | 1.218 |
| AK            | 0.010 | 0.020 |                | .015                     | .015  | .015  | .015  | .015  |
| AL            | 0.053 | 0.073 |                | .063                     | .063  | .063  | .063  | .063  |
| AM            | 0.240 | 0.260 |                | .250                     | .250  | .250  | .250  | .250  |
| AN            | 2.518 | 2.538 |                | 2.528                    | 2.528 | 2.528 | 2.530 | 2.530 |
| AO            | 84.39 | 90.39 |                | 87.39                    | 87.39 | 87.39 | 87.39 | 87.39 |
| AP            | 0.261 | 0.266 |                | .262                     | .262  | .262  | .0262 | .262  |
| AQ            | 0.053 | 0.073 |                | .063                     | .063  | .063  | .063  | .063  |
| AR            |       |       |                |                          |       |       |       |       |
| AS            |       |       |                |                          |       |       |       |       |
| AT            |       |       |                |                          |       |       |       |       |
| Accept/Reject |       |       |                |                          |       |       |       |       |

|                                 |                                  |
|---------------------------------|----------------------------------|
| <b>Measured by:</b> DAS 44 9-89 | <b>Date:</b> 17-03-13 / 17/03/14 |
| <b>Audited by:</b> DAS 68 9-89  | <b>Date:</b> 17-03-13            |
| <b>Preliminary Approval:</b>    | <b>Date:</b>                     |

| Rev | Date     | Change               | Revised by | Approved |
|-----|----------|----------------------|------------|----------|
| A   | 02.12.13 | New Issue            | KJ/RF      |          |
| B   | 07.05.08 | Dimension AP revised | KJ/JLM     |          |
| C   | 08.04.21 | Reformat             | KJ/JLM     |          |
| D   | 12.07.31 | Dwg Rev updated      | KJ         |          |



SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 157223 MLC  
17-02-22

D2893-1 SUPPORT

#### NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION  
MIN UTS = 170 KSI (38 HRC)  
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.78 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:  
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

RELEASED  
2011-07-28

| C          | RMV FINISH, ADD 3M 2216, ADD H925 MATL OPTION | CP | 11.07.15 |
|------------|-----------------------------------------------|----|----------|
| B          | UPDATE DIMS AS MFG, PRIME INSIDE              | PH | 07.03.16 |
| A          | NEW ISSUE                                     | CP | 01.01.10 |
| REV.       | DESCRIPTION                                   | BY | DATE     |
| DESIGN     |                                               |    |          |
| DRAWN      |                                               |    |          |
| CHECKED    |                                               |    |          |
| MFG. APPR. |                                               |    |          |
| APPROVED   |                                               |    |          |
| DE APPR.   |                                               |    |          |
| DATE       | 11.07.15                                      |    |          |

|                                                                                                                                                                                                                                                                        |                        |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------|
| <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                               |                        |
| DRAWING NO.<br>D2893                                                                                                                                                                                                                                                   | REV. C<br>SHEET 1 OF 1 |
| TITLE<br>Ø2.750 SUPPORT                                                                                                                                                                                                                                                | SCALE<br>NTS           |
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